

Date: Wednesday, 10/09/2008 1:52:47 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TOW CAP
Job Number : 41931	
Estimate Number : 10483	
P.O. Number :	Part Number : D3401041
This Issue : 10/09/2008 S.O. No. :	Drawing Number : D3401 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 36216	Material :
Written By :	Due Date : 20/10/2008 Qty: 20 Um: Each
Checked & Approved By : <u>J.D. 08.9.10</u>	
Comment : Est. A 05.09.01 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R3500	6061 RD bar 3.50
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Comment: Qty.: 0.3675 f(s)/Unit Total: 7.3500 f(s)
Inventory

Material: 6061-T6 Round Bar (QQ-A-225/8 or QQ-A-200/8)
(M6061T6R3.500) Batch: M106534 J.F. 08/09/12 (21)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut Blanks 4.20" Long

J.F. 08/09/12 (21)

3.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: DOOSAN LATHE
Turn as per Folio FA532 & Dwg D3401
Folio Rev: B Dwg Rev: B
Deburr

J.F. 08/09/12 (20)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/09/12 (20)

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Haas #1
Machine as per Folio FA532 and Dwg D3401
Dwg Rev: B Folio Rev: B
Deburr & Buff rod as per Dwg D3401

Identify as D3401-1

H.A. 08/09/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3401-041 PAR #: N/A Fault Category: Prod / Machine NCR: Yes No DQA: D Date: 08/10/10
D3371-0131003 Resolution: Scrap 0412-742-041 Disposition: SCRAP QA: N/C Closed: A Date: 08/10/10

NCR: 41931		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/12	3.0	One part was crush by the chuck. Forgot to put the plug in. RC operator error.	<u>AS/ML</u>	Scrap and Destroy part Replse B# <u>MW6534</u>	JF 08/09/12	<u>S</u> 08/09/12	<u>AS/ML</u>	<u>S</u> 08/09/12

NOTE: Date & initial all entries

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Part Number: D3401041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8/08/07/25

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill and c'sink using DT8782 as per Dwg D3401

FF 08/10/01

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-10-01

(20)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MJ- 08-10-02 (20)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8-10
320 OF
8-40

M-1 08/10/03

(20X)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-03 (20)

12.0

NAS1330C3KB116

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Insert

Pick:

Qty Part number

Description Batch

4 NAS1330C3KB116 Insert

Assemble as per Dwg D3401

Identify as D3401-041

M 17524

FX 08/10/09

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	/							

NOTE: Date & initial all entries

Date: Wednesday, 10/09/2008 1:52:48 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW CAP

Job Number: 41931

Part Number: D3401041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

808/10/09 (x20)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

F-P

6

M-1

08/10/09

(20X)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/10

Job Completion



mf 08-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

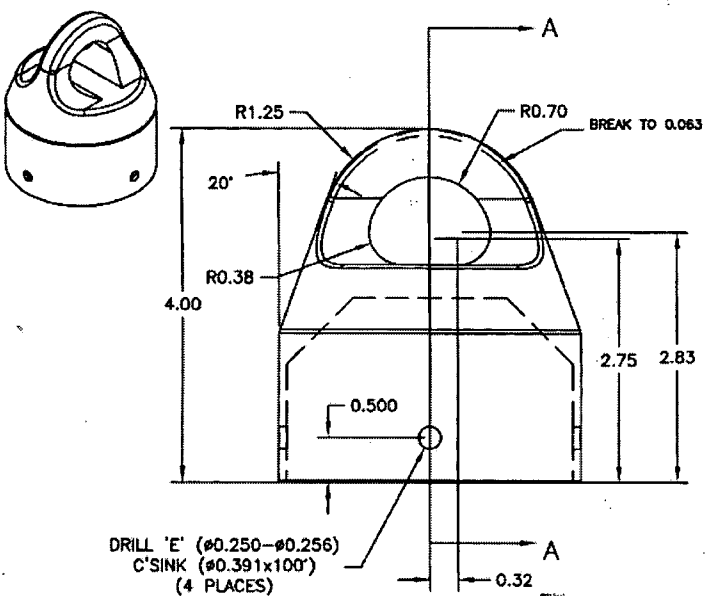
• Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

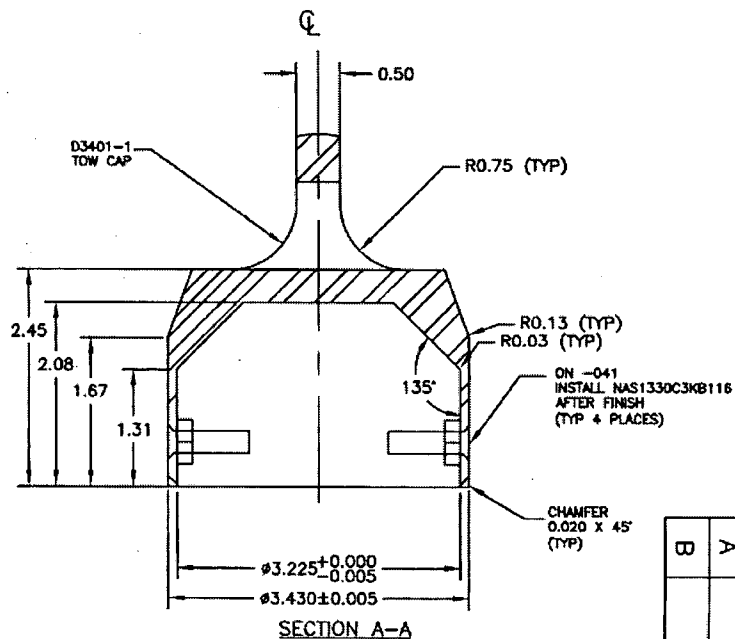
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	/							

NOTE: Date & initial all entries

DART



D3401-1 TOW CAP



D3401-1/-041 TOW CAP

D3401-1 TOW CAP

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6 $\phi 3.500$ ROUND BAR PER QQ-A-225/8 OR AMS-QQ-A-200/8 (REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3401-041 TOW CAP

- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

D3401-041 TOW CAP PARTS LIST

PART NUMBER	DESCRIPTION
D3401-1	TOW CAP
NAS1330C3KB116	INSERT

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
PH	PH	PORT HADLOCK, VA
CHECKED	APPROVED	DRAWING NO.
05.06.09	05.02.24	D3401
DATE	TITLE	SCALE
05.06.09	TOW CAP	1:2
A	NEW ISSUE	
B	CHAMFER INSIDE, REMOVE RADIUS	

RELEASED
05-08-07

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41931